

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004526**Date Inspected:** 03-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** deck panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG assembly bay 2

QA performed Phased Array Ultrasonic Testing (PAUT) following the guide lines of UT procedure titled "Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds" after Caltrans NDE technicians performed the preliminary scan with conventional Ultrasonic Testing (UT) in the tacked areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plates. This QA inspector performed 100 % PAUT in the areas that exhibited crack like indications with conventional UT. This QA inspector confirmed crack like indications as follows:

DP-243-001: (PAUT)

Weld# 1 – 3 tacks PAUT'ed – 2 indications verified\*

Weld# 4 – 2 tacks PAUT'ed – 1 indications verified\*\*

Weld# 5 – 2 tacks PAUT'ed – 0 indications verified

Weld# 6 – 2 tacks PAUT'ed – 0 indications verified

\* weld 1 "Y" location 8245mm / depth 9.41mm / dbs 15.9 / length 40mm.

\* weld 1 "Y" location 10035mm / depth 9.17mm / dbs 7.9 / length 50mm.

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\*\* weld 4 “Y” location 5225mm / depth 8.23mm / dbs 4.0 / length 15mm.

QA did not complete the PAUT on this deck panel. Weld 1 is complete and welds 2 thru 10 are only partially complete.

NOTE: The following are the dbs reference levels obtained from known cracks in three macroetch samples:

1.2mm macroetch crack sample 5-3 DP-564: 7.9 dbs.

2mm macroetch crack sample 5-9 DP-564: 7.3 dbs.

4mm macroetch crack sample 5-6 DP-564: 6.6 dbs.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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